

Date: Wednesday, 03/06/2009 2:31:45 PM
User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GROUND HANDLING CRANK ASS'Y	
Job Number :	48341	Part Number :	D3943041	
Estimate Number :	13998	Drawing Number :	D3943 REV A	
P.O. Number :		Project Number :	N/A	
This Issue :	03/06/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	A	
First Issue :	1/1	Type :	PURCHASED PARTS	
Previous Run :	48341	Material :		
Written By :		Due Date :	10/06/2009	Qty: 1 Um: Each
Checked & Approved By :	C209/06/03			
Comment :	Est Rev:A New Issue 09-06-02 EC Verified By: JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 8709

C209/06/03

Purchase Part Number: 8143919

Supplier: Princess Auto

Certificate of conformity is required

Description: 4000 lbs lever chain hoist

(1)

2.0	8143919	Lever chain hoist 4000lbs
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m111621



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Lever chain hoist 4000lbs

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C209/06/03

(1)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

B209/06/03

(1)

5.0	D39545	Chain Lug
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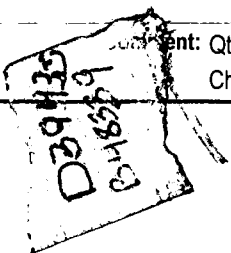


Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Chain Lug

B48339

B209/06/03

(1)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 2:31:45 PM
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Part Number: D3943041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D39549

GWT Chain Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GWT Chain Pin

AB 09.06.03

7.0

D39437

Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Stud

AB 09.06.03

8.0

D39435

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Plate

AB 09.06.03

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Disassemble chain host as per dwg

AB 09.06.03

Drill handle ass'y (D3943-051) as per dwg

AB 09.06.03

→ Weld D3943-7 stud and D3943-5 plate as per dwg

PL 09.06.04

Weld D3954-5 and -9 to supplied chain, discard hooks

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****mask chain as per dwg*****

M 10.07.01

Powder Coat handle (D3943-051) and chain lug (D3943-5) as per dwg Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

10:30

OVEN TEMPERATURE:

320°

FINISH TIME:

11:00

PL 09.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 48341

Part Number: D3943041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D39433	Handle Extension
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle Extension

B 48338

03 06 03

12.0	D26904	Lanyard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lanyard

B 48372

03 06 03

13.0	D35851	Set Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Set Screw

B 31571

9/6/3

SP

14.0	D3949041	Remove before Flight Flag Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Remove before Flight Flag Assembly

B 48280

03 06 03

15.0	D39547	Ratchet Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Ratchet Lug

B 48345

03 06 03

16.0	AN410A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt

M 108986

9/6/3

SP

17.0	AN960416	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
washer

M 111808

9/6/3

SP

18.0	MS210424	USE MS21042L4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Nut

M 5461

9/6/3

03 06 03

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.06.03	1C	ANS-7A M110625 AN960 JDS16 M111279 x2 MS2104265 M111127	DB	09.06.03	1	DB 09.06.03	DB 09.06.03	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 48341

Part Number: D3943041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

S1475

inventory



9/6/3



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
inventory

M17303

SP

20.0

3408A59

Ball Plunger



(1x)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Ball Plunger

M111535

9/6/3

SP

21.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



(2)

M110684



(2)

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
1/4-20 UNCx3/4 S.H.C.S.

M108200

9/6/3

SP

22.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per dwg

AD 09-06-04 (1)

Calibrate as per dwg

AD 09-06-04 (1)

23.0

QC5

INSPECT WORK TO CURRENT STEP



09-06-04 (1)



Comment: INSPECT WORK TO CURRENT STEP

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O 48340

MF 09-06-04

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



W/O 09-06-04 Re-processed
MF 09-06-04